

ASAP

Work Order ID 134991

July 23, 2015 10:29:08 AM

134991

Page 1

Item ID: D4039-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fwd Bracket Assembly

Stop *NS2*

Start Date: 7/23/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/7/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: SA

Part: 150723 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4039

B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Assemble lanyard to bracket as per dwg

3x

15/08/24

DAS
36
9-89

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

3

15-08-24

DAS
9
9-89

120

Identify as per dwg & Stock Location: st471

0.00

120

Packaging

Memo

0.00

Packaging

3

27
9-89

AUG 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

Work Order ID 134991***134991***

Page 2

Item ID: D4039-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Bracket Assembly

Stop

NS2

Start Date: 7/23/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/7/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

ML5

AUG 25 2015

20150825

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

July 23, 2015 10:29:15 AM

Page 1

Work Order ID: 134991

134991

Parent Item: D4039-041

D4039-041

Parent Item Name: Fwd Bracket Assembly

Start Date: 7/23/2015

Required Date: 8/7/2015

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.12.15 verified by:EC

IPP REV

B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4039-1 *D4039-1* Fwd Bracket		Manufactured	No			100	Each	0.0000	1	2		15/08/24	DAS 36 9-89
D2690-6 *D2690-6* Lanyard		Manufactured	No			100	Each	36.0000	1	2		15/08/24	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST009				10					
				134004				10					
				ST012a				26					
				134527				26					
BLRS-010 *BLRS-010* Quick Release Pin (1/4" x 1")		Purchased	No			100	Each	26.0000	1	2		15/08/24	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				4					
				121374				4					
				ST550				16					
				m132518				10					
				m132778				6					
				ST551				6					
				m131692				6					

Picklist Print

July 23, 2015 10:29:15 AM

Page 2

Work Order ID: 134991

Parent Item: D4039-041

Parent Item Name: Fwd Bracket Assembly

134991

D4039-041

Start Date: 7/23/2015

Required Date: 8/7/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-11

Purchased

No

100

Each

372.0000

1

2

MS27039-1-11

Screw

**

DAS

36

9-89

15/08/24

Location

Loc Qty

Loc Code

CA

253

124326

253

GA

32

125654

13

9662

19

ST285

87

m131317

87

3

MS21042L3

Purchased

No

100

Each

1,184.000

1

2

MS21042L3

Nut

**

DAS

36

9-89

15/08/24

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

323

M131317

323

ST305

468

116549

12

126333

49

M128754

2

M132123

17

M132382

388

3

Picklist Print

July 23, 2015 10:29:15 AM

Page 3

Work Order ID: 134991

134991

Parent Item: D4039-041

D4039-041

Parent Item Name: Fwd Bracket Assembly

Start Date: 7/23/2015

Required Date: 8/7/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

100

Each

1,804.000

3

6

NAS1149D0363.J

Washer

EP 15/08/24

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

1043

m128429

134

m132677

909

ST269

192

m126319

7

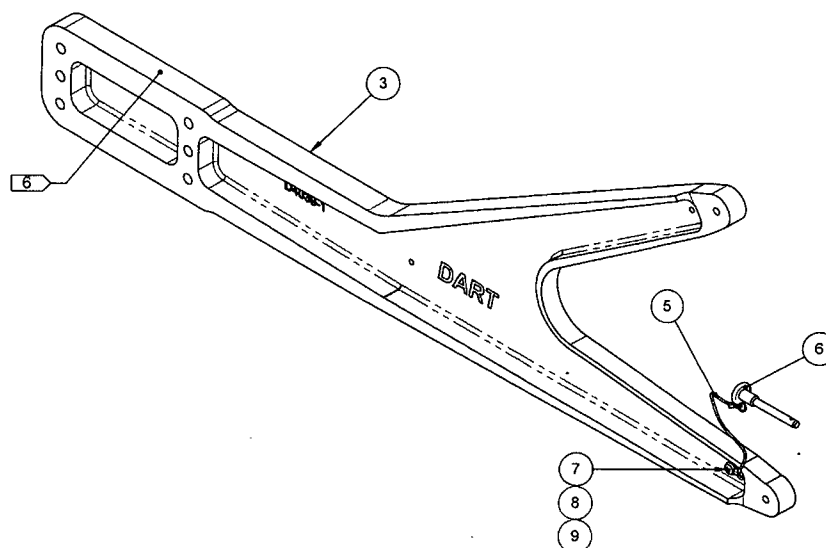
m131618

1

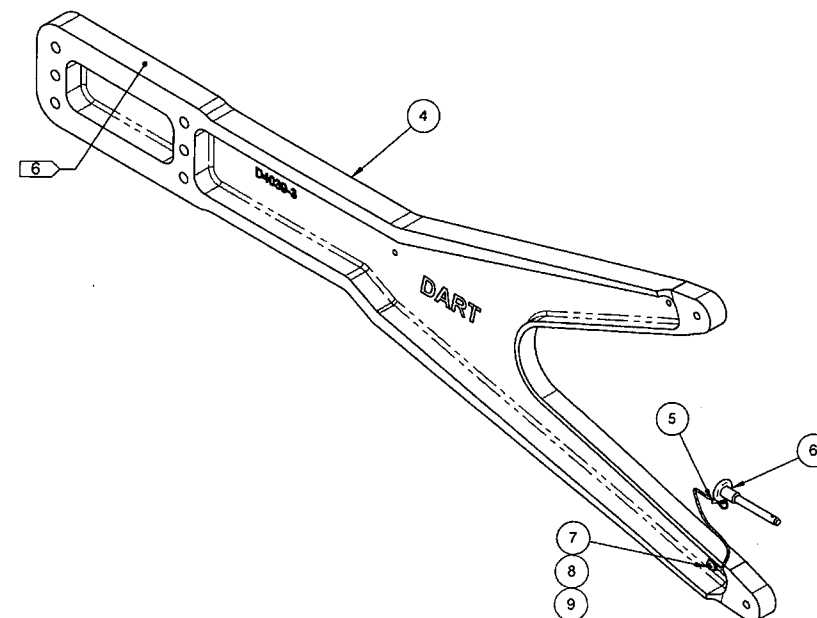
m132317

184

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

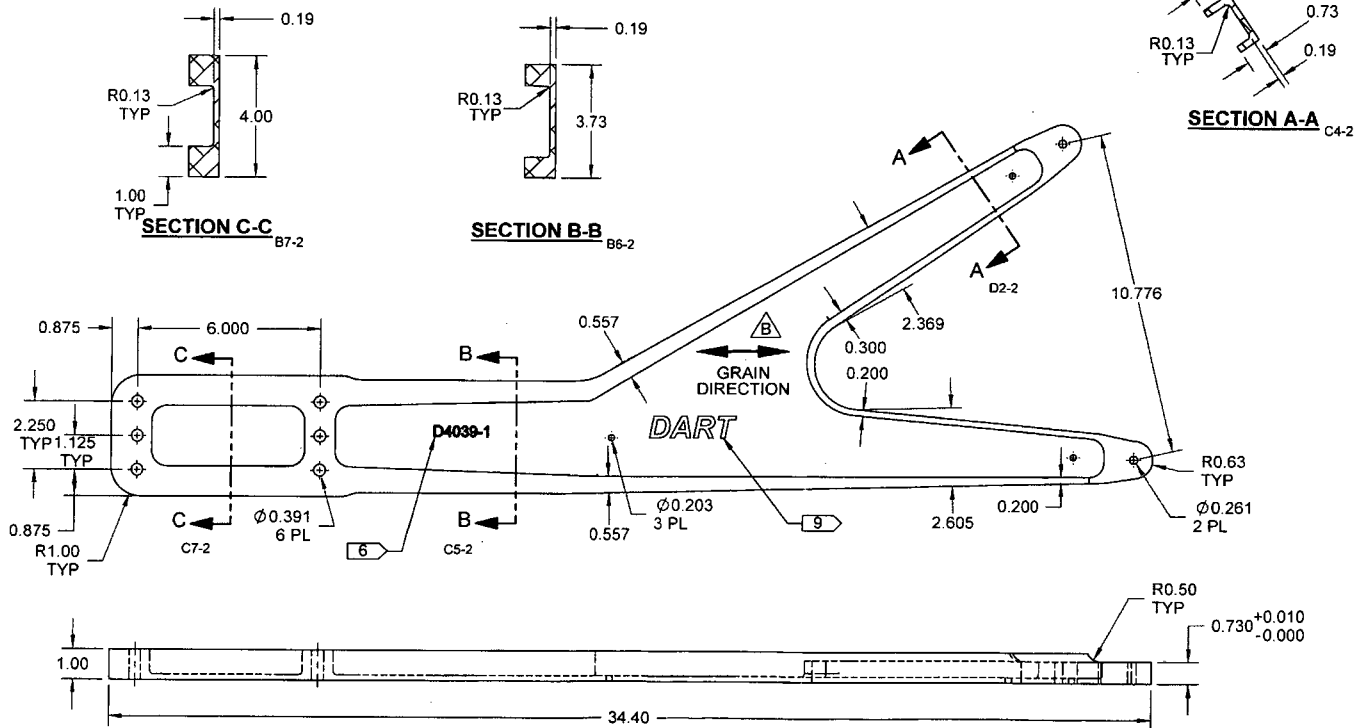
RELEASED
2010-09-27

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: N/A



REV.	DESCRIPTION	BY	DATE
B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN B6-3	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4039	REV. B
TITLE BRACKET	SHEET 1 OF 3
	SCALE NTS
COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



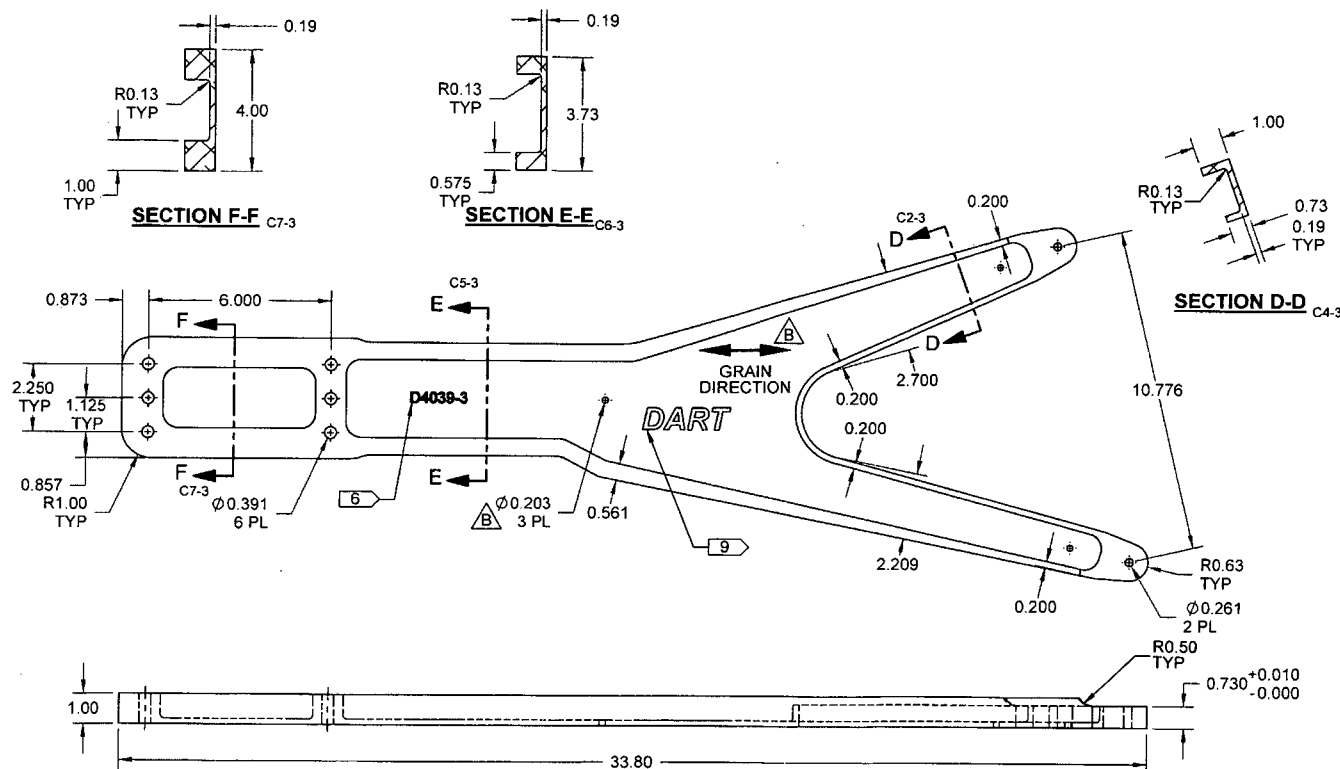
D4039-1 FWD BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.64 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1 REV.B.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4039	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.04.28	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-09-27



D4039-3 AFT BRACKET

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
 - 7) WEIGHT: 6.23 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4039-3 REV.B.SLDPRT"
 - 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASED
2010-09-27

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4039	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.04.28	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	